

Date: Monday, 1/7/2008 11:14:22 AM
User: Kim Johnston

Process Sheet

5

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MECHANICAL GROUND HANDLING WHEEL KIT
Job Number : 36615A	
Estimate Number : 12136	
P.O. Number :	Part Number : D206731041
This Issue : 1/7/2008 S.O. No. :	Drawing Number : DSK 093 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : 2 C
Previous Run : 36211A	Material :
Written By :	Due Date : 1/31/2008 Qty: 1 Um: Each
Checked & Approved By : <u>08.01.07</u>	
Comment : est rev A 01.02.01 new issue EC	
Est Rev:B As per Rev B 07-02-13 JLM	
est rev C 07.05.14 rev C IIN Ec	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D33355 spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

qty	Part Number	Description	batch
1	D3335-5	spring	<u>B33948</u>

09.01.14

2.0 D3353041 LUG ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
LUG ARM WELDMENT
Batch: B42475 ✓

09.01.14

3.0 D3354041 LEFT ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

qty	Part Number	Description	batch
1	D3354-041	Left Arm Weldment	<u>B36213</u> ✓

09.01.14

4.0 D3354043 RIGHT ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
RIGHT ARM WELDMENT
batch: B42477 ✓

09.01.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Job Number: 36615A

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33561

pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	D3356-1	pin

batch

B36640 ✓

Pl09.01.14

6.0

D3397041

wheel ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
2	D3397-041	Wheel ass'y

batch

B34623 ✓

Pl09.01.14

7.0

113800

GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	113-800	GREASE FITTING

batch

M109604 *

Pl09.01.14

8.0

656051

flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
2	656-051	flat washer

batch

M105735 ✓

Pl09.01.14

9.0

663079

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	663-079	Lock washer

batch

M16362 ✓

Pl09.01.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 36615A

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Seq. #:

Machine Or Operation:

Description :

10.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	AN5-23A	Bolt

batch

M19278 ✓

Pl 09-01-14

11.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	AN960JD516	Washer

batch

M109752 ✓

Pl 09-01-14

12.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
2	CP21	1/8" Cotter Pin 2" long

batch

M108200 *

Pl 09-01-14

13.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	MS21042L5	Nut

batch

M109297 ✓

Pl 09-01-14

14.0

SNF34

SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
1	SNF-34	SLOTTED NUT

batch

M109706 ✓

Pl 09-01-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Seq. #:

Machine Or Operation:

Description :

15.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	TP-2	Spring pin

batch

M16588

Pl 09-01-14

16.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty	Part Number	Description
1	TP-134	Spring pin

batch

M16362

Pl 09-01-14

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg DSK 093

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

Pl 09-01-14

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/01/14 @

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 36615

Pl 09/01/15 @

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/15 @

Job Completion



W 09/01/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

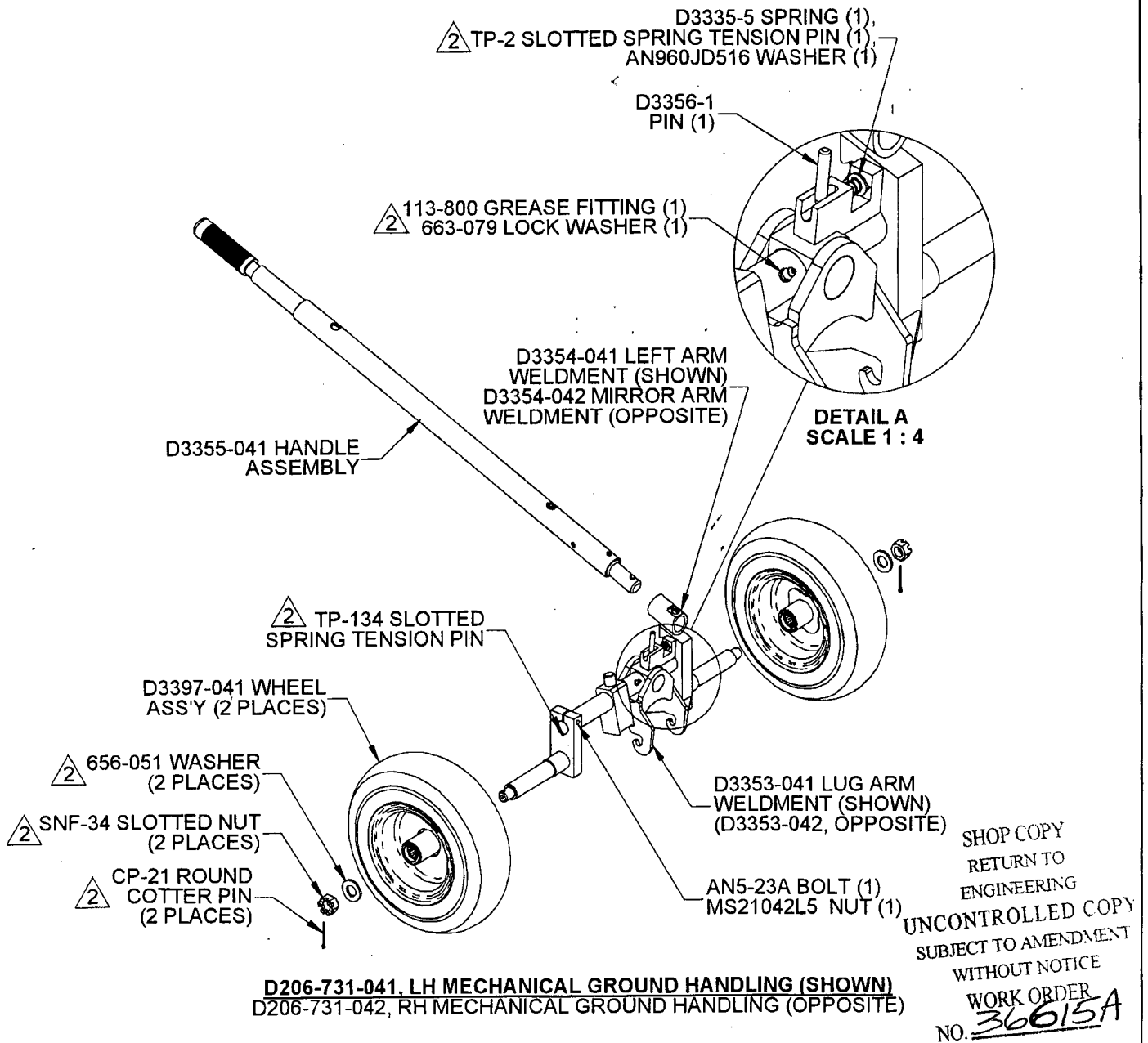
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.02.02

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 093	REV. B SHEET 1 OF 1
DATE 07.02.02		TITLE MECH. GROUND HANDLING	SCALE 1:10
REV	DATE	DESCRIPTION	
A	05.02.10	NEW ISSUE	
B	07.02.02	REDRAWN	

**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.
- 2) SUPPLIER: SPAENAUER.

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